



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D3368-1  
Job Sheet 183443



Part No: D3368-1

Job Qty: 5 ea

Part Name: Pedal Lock Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 05.01.27 New issue KJ/JLM IPP Rev:B 08-07-17 add QC3 DD verified by:ec

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation     | 5 Ea  | 9/28/18    | 9/28/18  | 0.00      | 0.00    | Start Up Machining-2  |           | 18/10/17    |
| 100   | Bandsaw                | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 4.32    | Bandsaw1              |           |             |
| 105   | CNC Vertical Machining | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 4.32    | HAAS1-3               |           |             |
| 110   | QC                     | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC2 Machining-2       |           |             |
| 120   | QC                     | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC8 Machining-2       |           | 18-10-21    |
| 130   | HandFinish             | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.50    | HandFinish1           |           | 18/10/22    |
| 140   | Powdercoat             | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.27    | Powdercoat6           |           | 18-10-25    |
| 150   | QC                     | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC3                   |           | 38          |
| 160   | Packaging              | 5 pcs | 9/28/18    | 9/28/18  | 0.00      | 0.00    | Packaging3-1          |           | OCT 29 2018 |
| 170   | QC21-SA                | 5 Ea  | 9/28/18    | 9/28/18  | 0.00      | 0.00    | QC21                  |           | OCT 29 2018 |

Part Op 100 - Cut blanks as per folio

Descriptions: 105 - 1-Machine D3368-1 as per Folio FA499 and Dwg D3368 Identify as D3368-1 2-Deburr

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - \*\*\*Cover inside holes prior painting\*\*\* Heat oven at temperature for 45 minutes before putting part in oven

by: Start Time: 8:15 Oven Temperature: 320° Finish Time: 8:45

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item          | Component Name          | Quantity          | Operation             | Container |
|----------------------|-------------------------|-------------------|-----------------------|-----------|
| M6061T6B2.000X02.000 | 6061-T6 Bar 2.00 X 2.00 | 4.5000 ft (.9 ea) | 90-Start up Operation | EM 137341 |

### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated |
|-----------------------|----------------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6B2.000X02.000 | 5        | 10        | 0         |

### Part Specifications

Specifications could not be found.

|                              |  |              |         |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD           |  | Work Order:  | 183443  |
| Description: Pedal Lock Base |  | Part Number: | D3368-1 |
| Inspection Dwg: D3368 Rev: B |  | Page 1 of 1  |         |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments     |
|-------------------|---------------|------------------|--------|--------|----------------------|--------------|
| 10.25             | +/-0.030      | 10.257           | ✓      |        | Vernier              | 12 ps shop   |
| 7.250             | +/-0.010      | 7.252            | ✓      |        | Vernier              | VH5-01       |
| 0.107             | +/-0.010      | 0.100            | ✓      |        | ↓                    |              |
| 1.800             | +/-0.010      | 1.806            | ✓      |        | ↓                    |              |
| 0.750             | +/-0.010      | 0.749            | ✓      |        | ↓                    |              |
| Ø1.031            | +/-0.010      | 1.028            | ✓      |        | VH5-05               | Depth gage   |
| 45°               | +/-0.5°       | 45.2°            | ✓      |        | Cnc-17               | Angle Finder |
| 0.250             | +/-0.010      | 0.250            | ✓      |        | VH5-01               | Vernier      |
| 2.00              | +/-0.030      | 2.0015           |        |        | ↓                    |              |
| 7°                | +/-0.5°       | 7.3°             | ✓      |        | Cnc-17               | Angle Finder |
| Ø0.230            | +0.005/-0.000 | 0.230            |        |        | Gage Pin             |              |
| 1.250             | +/-0.010      | 1.250            | ✓      |        | VH5-01               |              |
| 1.075             | +/-0.010      | 1.075            | ✓      |        | ↓                    |              |
| R0.500            | +/-0.010      | R0.500           | ✓      |        | RG                   |              |
| 0.375             | +/-0.010      | 0.375            | ✓      |        | VH5-01               |              |
| 0.310             | +/-0.010      | 0.312            | ✓      |        | ↓                    |              |
| 1.450             | +/-0.005      | 1.454            | ✓      |        | ↓                    |              |
| 0.375             | +/-0.010      | 0.373            | ✓      |        | ↓                    |              |
| 5.125             | +/-0.010      | 5.1275           | ✓      |        | ↓                    |              |
|                   |               |                  |        |        |                      |              |
|                   |               |                  |        |        |                      |              |
|                   |               |                  |        |        |                      |              |
|                   |               |                  |        |        |                      |              |

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | VH8      | Audited by: | BA       | Prototype Approval: | N/A |
| Date:        | 18/10/16 | Date:       | 18-10-21 | Date:               | N/A |

| Rev | Date     | Change                            | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A   | 05.04.26 | New Issue                         | KJ/JLM     |          |
| B   | 05.05.25 | Dimensions and tolerances changed | KJ/JLM     |          |
| C   | 08.07.23 | 0.700 dimension removed           | KJ/DD      |          |

**DQA:**

Date:

Date:

**WORK ORDER NON-CONFORMANCE / UPDATE**

**Work Order update only**



|                                                   |  |                                                                                                                                            |  |                                                                   |  |  |  |
|---------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------|--|--|--|
| Work Order: 183443                                |  | DISPOSITION                                                                                                                                |  | AGAINST DEPARTMENT/PROCESS                                        |  |  |  |
| Part No. D3368-1                                  |  | Rework<br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |  | Water Jet<br>Prod. Eng. Coord.<br>Rec/Store/Packaging<br>Supplier |  |  |  |
| NCR No. 19-7133                                   |  | Step #: 110                                                                                                                                |  | QTY Effective: 1                                                  |  |  |  |
| Date: 18/10/17                                    |  | Description Work Order Deviation                                                                                                           |  | Disposition                                                       |  |  |  |
| Drill broke in hole while drilling.               |  |                                                                                                                                            |  | Scrap and destroy.<br>and replace<br>batch # S115943              |  |  |  |
| Completed By<br>18/10/20<br>Vincent White         |  | Lead hand / Supervisor<br>Approval Verification<br>D.E 18-10-20                                                                            |  | MRB (QS1042) Approval<br>PD 18-10-22                              |  |  |  |
| QC / QA Coordinator<br>Approval<br>PD 18-10-22    |  |                                                                                                                                            |  |                                                                   |  |  |  |
| Root Cause                                        |  | FAULT CATEGORY                                                                                                                             |  |                                                                   |  |  |  |
| Environment                                       |  | Temperature/Cure                                                                                                                           |  | Positioned Wrong                                                  |  |  |  |
| Design                                            |  | Set-up                                                                                                                                     |  | Outside Dimensions                                                |  |  |  |
| Doc/Data                                          |  | BOM/Route                                                                                                                                  |  | Over/Under tolerance                                              |  |  |  |
| Equip/Tooling <input checked="" type="checkbox"/> |  | Broken/Damage/Defect                                                                                                                       |  | Part Incorrect                                                    |  |  |  |
| Handling/Pre                                      |  | Inspection Incomplete/Unqualified                                                                                                          |  | Part Lost/Missing                                                 |  |  |  |
| Material                                          |  | Contamination                                                                                                                              |  | Part Moved                                                        |  |  |  |
| Internal Transport                                |  | Countersink                                                                                                                                |  | Drawing                                                           |  |  |  |
| Tribal Knowledge                                  |  | Cut Too Short                                                                                                                              |  | Finish                                                            |  |  |  |
| LOA                                               |  | Instructions Incomplete/Unclear                                                                                                            |  | Misread                                                           |  |  |  |
| Substation                                        |  | Drill Holes <input checked="" type="checkbox"/>                                                                                            |  | Turning Sequence                                                  |  |  |  |
| Past Expiry Date                                  |  |                                                                                                                                            |  |                                                                   |  |  |  |
| Misidentified                                     |  |                                                                                                                                            |  |                                                                   |  |  |  |
| No Re-verification                                |  | Pressure/Forced                                                                                                                            |  |                                                                   |  |  |  |
| Operator                                          |  | Bending                                                                                                                                    |  |                                                                   |  |  |  |
| Offset/Setup                                      |  | Centre Not Concentric                                                                                                                      |  |                                                                   |  |  |  |
| Supplier                                          |  | Cracks                                                                                                                                     |  |                                                                   |  |  |  |
| Training                                          |  | Crimp/Kink/Ripple/Wave                                                                                                                     |  |                                                                   |  |  |  |
| Use for Testing                                   |  | Cuffs                                                                                                                                      |  |                                                                   |  |  |  |
| Poor Information                                  |  | Crushing                                                                                                                                   |  |                                                                   |  |  |  |
| Rushing                                           |  | Heat Treat                                                                                                                                 |  |                                                                   |  |  |  |
| Product Improvement                               |  | Wave/Twist in Tube                                                                                                                         |  |                                                                   |  |  |  |
| Process Improvement                               |  | Marks/Chatter                                                                                                                              |  |                                                                   |  |  |  |
| Manufacturing Process                             |  |                                                                                                                                            |  |                                                                   |  |  |  |
| Past Due                                          |  | OTHER :                                                                                                                                    |  |                                                                   |  |  |  |